

Date: Tuesday, 31/03/2009 1:04:43 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MOUNTING LUG
Job Number : 46745	
Estimate Number : 10428	
P.O. Number :	Part Number : D32351
This Issue : 31/03/2009 S.O. No. :	Drawing Number : D3235 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 45398	Material :
Written By :	Due Date : 07/04/2009 Qty: 125 Um: Each
Checked & Approved By : <u>JLD 09.03.31</u>	
Comment : Est A 04.04.19 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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(125)

Comment: Qty.: 0.0717 f(s)/Unit Total : 8.6058 f(s)

Lug Extrusion

D2423 extrusion

Batch: 45800

Mat not out
Scrap

88 09/03/31

2.0	BAND SAW	BAND SAW
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(125)

Comment: Band Saw

Cut D2423 extrusion to 0.820"

Batch: 45800

88 09/03/31

3.0	D32351P	lug
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 120.0000 Each(s)

lug

N

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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(125)

Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA369 and Dwg D3235

2-Identify as D3235-1

3-Deburr

H.A

09/04/02

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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(125)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A

09/04/02

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 46745

Part Number: D32351

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk

09/04/03

(125)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

cmp / FL

09/04/06

(X125)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/04/06

(125)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

m/110939

START TIME:

6:55

OVEN TEMPERATURE:

320°

FINISH TIME:

7:25

FL

09/04/09

(25)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL

09-04-09

(125)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FL 09/04/14

(125)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/14

Job Completion



mk

09-04-14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 410145
Description: Mounting Lug		Part Number: D3235-1
Inspection Dwg: D3235 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.450	+/-0.010	4.451	✓			
0.306	+/-0.010	.305	✓			
1.85	+/-0.030	1.866	✓			
R1.20	+/-0.010	1.20	✓			
R0.125	+/-0.010	.125	✓			
0.400	+/-0.010	.403	✓			
0.735	+/-0.030	.725	✓			
Ø0.505	+0.005/-0.000	.508	✓			
R0.38	+/-0.030	.38	✓			
3.700	+/-0.005	3.701	✓			
0.375	+/-0.010	.376	✓			
0.750	+/-0.010	.753	✓			
Ø0.257	+0.005/-0.000	.258	✓			
R0.380	+/-0.030	.380	✓			

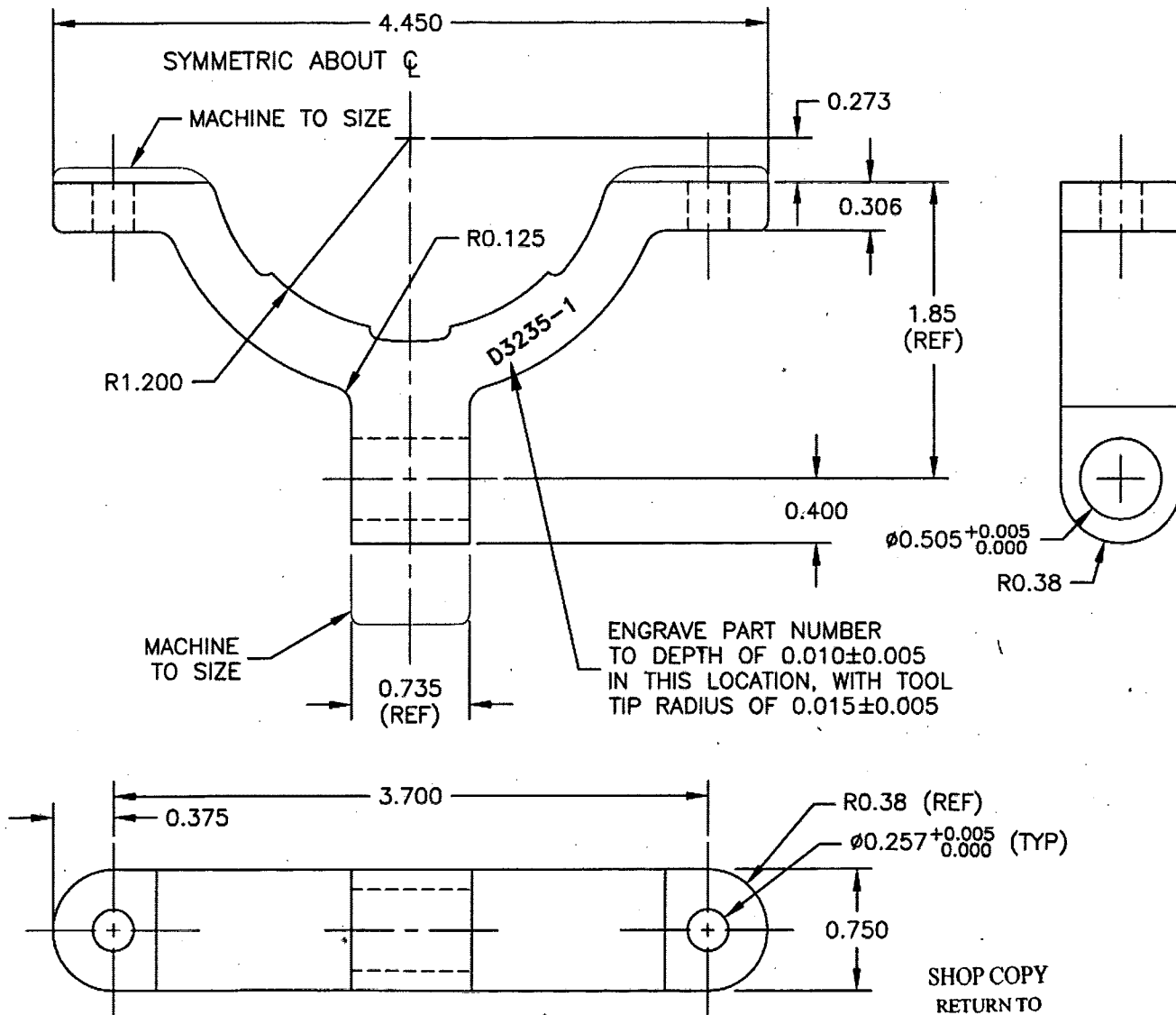
Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval: N/A
Date: 09/04/01	Date: 09/04/03	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



DESIGN LP	DRAWN BY LP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3235	REV. A SHEET 1 OF 1
DATE 04.03.02		TITLE MOUNTING LUG	SCALE 1:1
A	04.03.02	NEW ISSUE	

RELEASED
040405



D3235-1 MOUNTING LUG

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. 40145

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